

Work Order ID 52516

September 29, 2009 10:47:58 AM



Page 1

Item ID: D2648-3

Accept



Setup Start



Revision ID: D

Stop



Item Name: Wearpad

Start Date: 29/09/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 06/10/2009 Req Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 09-29

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2648

Rev D

WMT NOT PULLED

(Pb) →

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2648 ☐ ***** CUT WITH FILE D2648-

1***** ☐ Dwg Rev: D ☐ Prog Rev: D

☐

2-Deburr if necessary

HB 9-10-17

(L)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-10-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ Sorkhola

counted
(X)

back

one

for

temp he

Sorkhola

W/O: 52516		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.10.19	120	took qty x1 D2648-3 as template	S	9/10/19	(N)	6/10/20	S 09/10/19

Part No: D2648-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52516

September 29, 2009 10:47:58 AM



Page 2

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Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	NC BRAKE	0.00				47	0		
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 02- Identify as D2648-3								
150 	Large Fab	0.00				47	0		
Large Fab	Memo	0.00							
Large Fab	Qty Description Batch A/R 560Hardcoat 01-Weld as per Dwg D2648 using Jig DT 8210 02-Remove any weld that penetrated through Wearpad if necessary Rod # M109060								

N/A

SB 09/10/19

09.10.26

Work Order ID 52516

September 29, 2009 10:47:58 AM



Page 3

Item ID: D2648-3

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Setup Start



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Item Name: Wearpad

Start Date: 29/09/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00



2) Serial 127

(47)

0

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



2) Serial 122

Count
(47)

0

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

0.00



HP 09/10/09

(47)

0

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:15pm FINISH TIME: 2:45pm OVEN TEMPERATURE: 320°F

Work Order ID 52516

September 29, 2009 10:47:58 AM



Page 4

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Setup Start



Revision ID: D

Stop



Item Name: Wearpad

Start Date: 29/09/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 06/10/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

09-10-28

47

Quality Control

200

Identify as per dwg & Stock Location: FP-17

0.00



Packaging

Memo

0.00

09/10/26

47

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/10/30

MK 09-10-29

Quality Control

Picklist Print

September 29, 2009 10:47:57 AM

Page 1

Work Order ID: 52516



Parent Item: D2648-3RevD



Parent Item Name: Wearpad


Start Date: 29/09/2009

Required Date: 06/10/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010S16GA 		Purchased	No			100	sf	111.6200	1.5789	3.8683		
1010/1025 sheet 16GA												

RB 940-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	111.62	
105706	0.6	
111410	111.02	

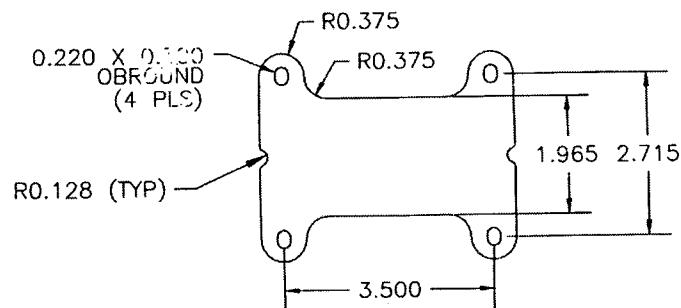
105706

49

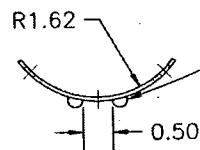
SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52546

D2648-1 FLAT PATTERN

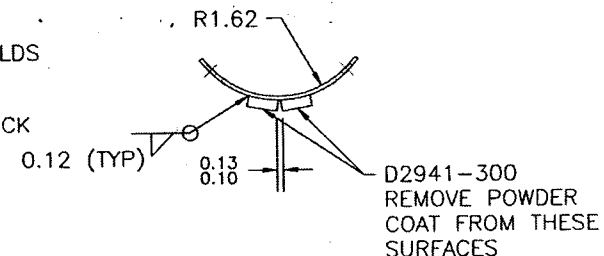


SECTION A-A

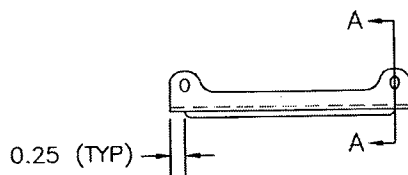


7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

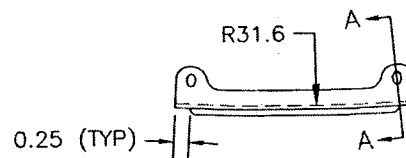
SECTION B-B



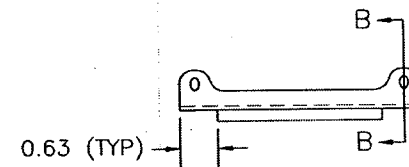
D2648-3 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND
(MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND
(MADE FROM D2648-1)



RELEASED
19.12.20 DS

BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBGROUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		TITLE WEARPAD
99.11.17		SCALE 1:2